

Date:  
User:Tuesday, 3/20/2007 2:36:12 PM  
Kim Johnston

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 31389  
 Estimate Number : 10035  
 P.O. Number : N/A  
 This Issue : 3/20/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 25355  
 Drawing Name : SADDLE BILLET  
 Part Number : D6101007  
 Drawing Number : D6101 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 6/1/2007 Qty: 200 Um: Each  
 Written By :  
 Checked & Approved By : 07.03.20  
 Comment : Est. A: 01.05.04 New Issue EC

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

3385

C 07/03/22

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

(200)

2.0

D6101007P

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)

7075-T7351 8.25X7.75X2.5

07/08/28

51

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

07/08/27

(50)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

07/08/28

51

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 07/08/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31389

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*7/07/08/28*

*51*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



*(5)*

Comment: FINAL INSPECTION/W/O RELEASE

*7/07/08/28*

Job Completion



*11 8/08/28*



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

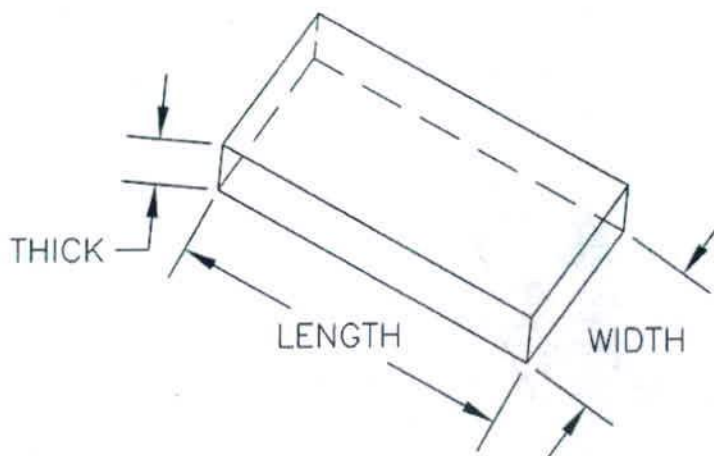
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED [Signature]	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31389

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A M CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

### SOLD TO:

AM CASTLE & CO  
3400 NO. WOLF ROAD  
FRANKLIN PARK, IL 60131

Serial Number  
4097183

CUSTOMER PO NUMBER: 01-84287		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-80		SHIP RUN/LOAD ID: 100975/8		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1049113	LINE ITEM: 1	SHIP DATE: 16-MAY-2007	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 1784 LB	QUANTITY: 1 PCS EST.	B/L NUMBER: 2012858		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

### Certified Specifications

AMS 4078/RevF  
ASTM B 209/Rev06  
BSS 7055/RevA  
DPS 4.713/RevN/AmdAF  
GSS16100/RevG

AMS-QQ-A-250/12  
ASTM B 594/Rev06  
CMMP 025/RevQ  
EAC MS1011/RevD  
MMS 159/RevN

AMS-STD-254  
BAC 5039/RevH  
CSTI 003/RevC  
GAMP 9001/RevE  
PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 381369A8 Cast 972 Drop 75 Ingot 4

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	68.4 : 68.6 (472 : 473)	56.2 : 56.9 (387 : 392)	10.5 : 10.9
Conductivity %IACS :			42.1 Min	42.4 Max	
(MS/M) :			24.4 Min	24.6 Max	

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.12	0.22	1.53	0.01	2.54	0.19	5.65	0.02	0.01	0.01	0.03

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EA	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS CORP.

DATE RCVD 5/22/07

IAC 6879

APPROVED BY AW-2pgs.





05-22-'07 08:23 FROM-

**KAISER  
ALUMINUM**

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

T-913 P002/028 F-231

**CERTIFIED TEST REPORT**

Serial Number

4097183

**TEST NOTES**

Metal represented by this test report was immersion  
ultrasonically tested from one side and meets the Class A  
and Class B requirements of all specifications referenced  
on this test report.

**CERTIFICATION**

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A.  
AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH  
IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE.  
TEST REPORTS ARE ON FILE SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER  
ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE  
PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

**BILL POYNOR, LABORATORIES SUPERVISOR**

*Bill Poyner*

